

Date: Thursday, 02/04/2009 2:22:28 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BELL 204 STEP
<b>Job Number</b> : 46819	
<b>Estimate Number</b> : 12416	
<b>P.O. Number</b> :	<b>Part Number</b> : D204618011
<b>This Issue</b> : 02/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 34979	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/04/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.02</u>	
<b>Comment</b> : Est Rev:D Add GGH Number 06-05-18 JLM EST REV E fixed eyebolt issue 07.06.26 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*Handwritten: HJ for JUD 09/04/27*



**Comment:** Photocopy bluefile & type labels per PPPD204-618-01 CHG002

*Handwritten: 8.0.6.5.1*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Pick Packing Kit

3.0	D2022101	Spacer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Spacer  
 batch: B41528

*Handwritten signature*

4.0	D2017121	Step Strut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Strut  
 Batch: 43575

*Handwritten signature*

5.0	D2017123	Step Strut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Strut  
 Batch: B43576

*Handwritten: PU 9/4/27 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL 204 STEP

Job Number: 46819

Part Number: D204618011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2017125

Step Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Strut

Batch:

34982 2X

B46944 x6

8/29/04/50

7.0

D2017127

Step Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch:

43577

8.0

D2017129

Step Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch:

43578

9.0

D2017131

Step Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch:

34983

10.0

D2349

Mount Plate (204 Steps)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Mounting Plate(204 Step)

Batch:

B34986

11.0

D2460

Step Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Ass'y

Batch:

B46901

12.0

AN45A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch:

M109061

PC 9/5/27 (4)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL 204 STEP

Job Number: 46819

Part Number: D204618011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	AN47A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bolt M10 8928

14.0	AN410A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bolt M10 8986  
Batch:

15.0	AN411A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt M10 6605  
batch:

16.0	AN414A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt M10 7534  
Batch:

17.0	AN511A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt M110 363  
Batch:

18.0	AN44 7A	EYEBOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
EYEBOLT M10 86 38  
\*\*\*\*\*ENSURE THIS IS AN44-7A EYEBOLT NOT AN4-47A BOLT\*\*\*\*\*

19.0	AN960JD416	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)  
Washer M110 363  
Batch:

PC 9/9/12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: BELL 204 STEP

Job Number: 46819

Part Number: D204618011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Batch: M110523

21.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Batch: M107499 7X M160450 25

22.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M109840

23.0

MS20600AD4W6

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Rivet

Batch: M103481 23X 1X M111424

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-618-011

Location:

PPP Rev:

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries